

Work Order ID 148066 -1

June 23, 2016 8:27:56 AM

148066

Page 1

Item ID: D350-615-041

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: GHW Modification, Fits LH or RH

Stop

NS2

Start Date: 8/5/2016 Start Qty: 20.00

Required Date: 8/17/2016 Req'd Qty: 20.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan: S4Date: 6/23/16 Tooling:

Date:

Run Start

NR1

QC:

Date: SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D350-615-041

B

JUL 11 2016

DAS
21
9-89

16-07-20

100

Document Control

0.00

100

DC

Memo

0.00

Doc.Control -USB or Paperwork

Photocopy bluefile and type labels with Eurocopter part# (2 CHW Kits per box)
as per PPP D350-615-041 CHG003

Pick kit

JUL 11 2016

DAS
6
9-89

4 28 SEP 16 2016

110

110

Small Fab

Memo

0.37

Small Fab

Assemble D2282-041 with D2282-043 as per Dwg D350-615 ***Only engage
one thread on three 5/16-18-015C bolts***DAS
30
9-89

4

SEP 12 2016

120

QC5- Inspect part completeness to step on W/O

0.00

120

QC

Memo

0.07

Quality Control

DAS
38
9-89

41

SEP 13 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
CAD 12 20-9 RQ 20-9 20-9				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					

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Item ID: D350-615-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: GHW Modification, Fits LH or RH
Start Date: 8/5/2016 Start Qty: 20.00 ***20*** Cust Item ID:
Required Date: 8/17/2016 Req'd Qty: 20.00 ***20*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC4- 100% Inspect kits for completeness	0.00							
130						4		SEP 13 2016	DAS 6 9-89
QC	Memo	0.10							
Quality Control									
140		0.00							
140						4	28	SEP 16 2016	9-89
Packaging	Memo	0.00							
Packaging	Identify with Eurocopter and Dart part# using permanent ink stamp and pack for shipping as per PPP D350-615-041 Location :FG023								
150	QC21- Final Inspection - Work Order Release	0.00							
150							DAS 21	SEP 19 2016	9-89
QC	Memo	0.33							
Quality Control									

DAS
21
9-89

SEP 19 2016

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
2A7 2 2A8				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐		OTHER : _____	

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1 48066

D350-615-041

Required Qty: 20.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D2282-041

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
GA	1	B 146651
145998	1	

D2282-043

D146572 (10K) B145576

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST583	139	
<u>m134359</u>	19	
m134839	20	
m134942	100	

DAS
6
9-89

JUL 11 2016

Picklist Print

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Work Order ID: 148066

148066

Parent Item: D350-615-041

D350-615-041

Parent Item Name: GHW Modification, Fits LH or RH

Start Date: 8/5/2016

Required Date: 8/17/2016

Start Qty: 20.00

Required Qty: 20.00

D3015-3

Manufactured No

110

Each

264.0000

3

60

D3015-3

Locknut

**

DAS
6
9-89

Location

Loc Qty

Loc Code

FG

18

95758

8

96151

10

ST015

46

141898

46

ST025A

200

146273

200

46

14

5/16WC

Purchased

No

110

Each

189.0000

12

240

5/16WC

Washer

**

ST X 135291

DAS
6
9-89

1
188
50
233

Location

Loc Qty

Loc Code

ST583

189

m134839

189

183

7/16-14-050C

Purchased

No

110

Each

42.0000

1

20

7/16-14-050C

SS Bolt 7/16 5"K Long (92198A672)

**

DAS
6
9-89

Location

Loc Qty

Loc Code

ST584

42

m134349

42

20

D3015-5

Manufactured

No

110

Each

28.0000

1

20

D3015-5

SS Nylock Nut 7/16

**

DAS
6
9-89

Location

Loc Qty

Loc Code

ST025A

28

141899

28

20

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Shop Packet Print

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Picklist Print

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Work Order ID: 148066

148066

Parent Item: D350-615-041

D350-615-041

Parent Item Name: GHW Modification, Fits LH or RH

Start Date: 8/5/2016

Required Date: 8/17/2016

Start Qty: 20.00

Required Qty: 20.00

7/16WC

Purchased

No

110

Each

130.0000

2

40

7/16WC

Washer, SS Flat 7/16

Location

Loc Qty

Loc Code

ST584

130

m134751

30

m134839

100

30
10

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Shop Packet Print

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